

# Work Order ID 68605



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Monday, April 18, 2011 12:51:39 PM

Item ID:	D4019-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib					
Start Date:	4/18/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	4/25/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan: <i>MF</i>	Date: <i>11-04-27</i>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4019	D

100		0.00							
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D4019 2- remove identification marks and deburr			<i>SAD 11-04-22</i>					

*8*

110	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00		<i>8/11/04/27</i>					
Quality Control									

*XS*

120	Identify as per dwg & Stock Location: <i>WA</i>	0.00							
Packaging	Memo	0.00		<i>SAD 11-04-27</i>					
Packaging									

*8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68605**

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Item ID: D4019-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 4/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28  
ME  
11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 18, 2011 12:51:46 PM

Page 1

Work Order ID: 68605

Parent Item: D4019-3

Parent Item Name: Rib



Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC IPP Rev:B as  
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg revC  
DD 10.04.20 verified by:EC IPP Rev:D as per dwg revD DD 10.08.18  
verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS0.750W.06 2		Purchased	No			100	f	273.3218	1.75	11.05263			



6061-T6 SQ Tube .75 x .75 x .062W



SAD 11-02-22

Location	Loc Qty	Loc Code
MAT006	69.32179	
104422	4	
116687	50.32179	
9671	15	
MAT013	204	
117400	204	

~~8.6842~~

11.0526

3.6842

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

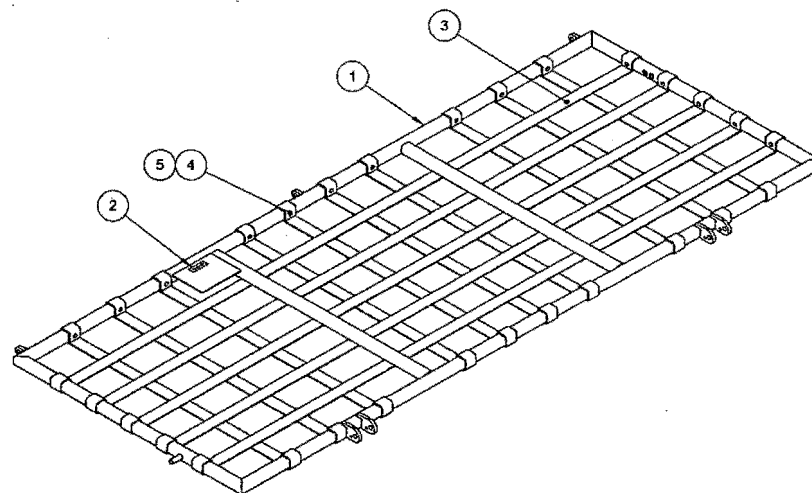
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W3	BLIND RIVET
5	30	NAS1149DN416J	WASHER



**D4019-041 LIGHT LID SHORT BASKET ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68605

*R/H-04-18*

**RELEASED**  
10.08.12  
ECN 10-596

NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: NONE  
7) WEIGHT: 4.83 lbs

D	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-243, UPDATED VIEW E ACCORDINGLY (A7-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2). SECTION B-B REV'D (D6-3). DIM. ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>ALS</i>		
CHECKED	<i>ALS</i>		
MFG. APPR.	<i>ALS</i>		
APPROVED	<i>ALS</i>		
DE APPR.	<i>ALS</i>		
DATE	10.08.05		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4019</b> REV. D SHEET 1 OF 4 TITLE <b>LIGHT LID SHORT BASKET</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

D

C

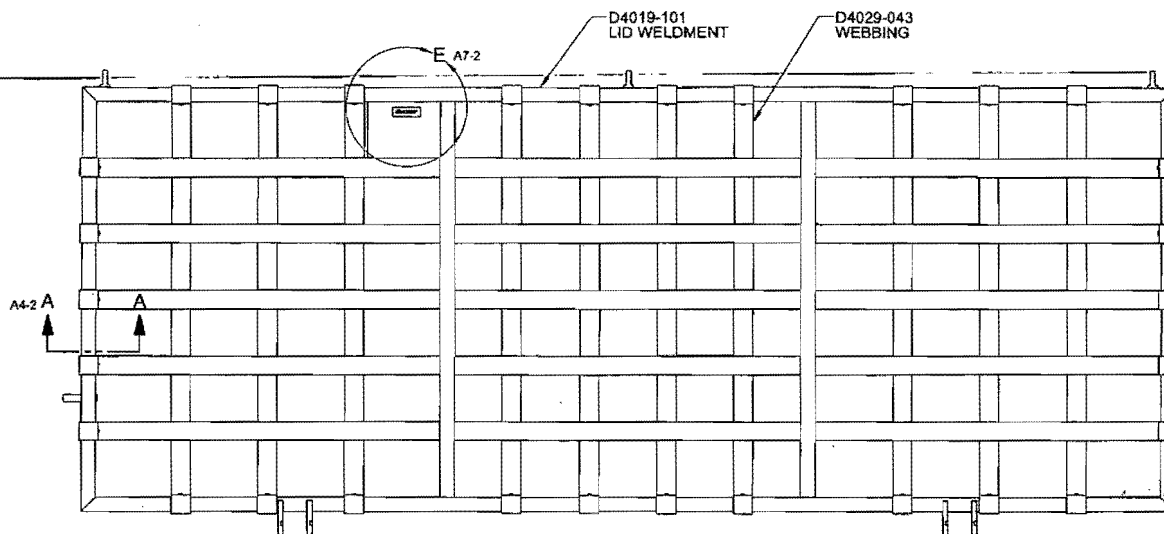
C

B

B

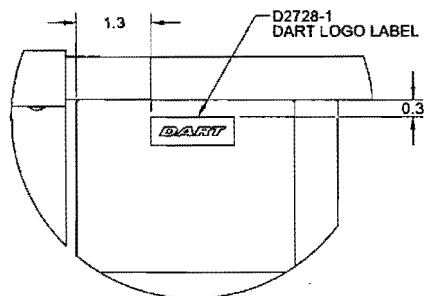
A

A

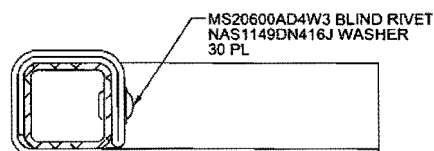


**D4019-041 LIGHT LID SHORT BASKET ASSY**

*u/068605*



**DETAIL E D6-2**



**SECTION A-A C7-2**

**RELEASED**  
10 DEC 12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. <b>D4019</b>	REV. D
MFG. APPR.	SC	SHEET 2 OF 4	
APPROVED	SC	TITLE <b>LIGHT LID SHORT BASKET</b>	SCALE NTS
DE APPR.	SC	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.08.05	THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

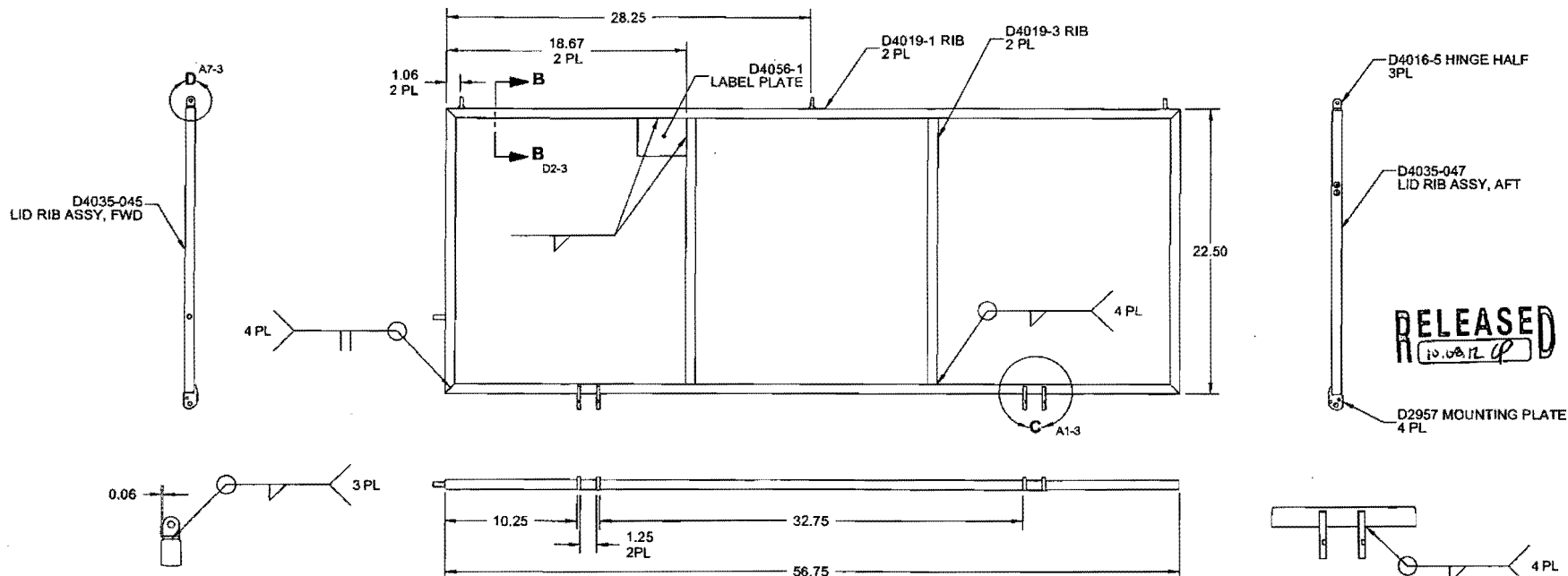
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4019-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	3	D4016-5	HINGE HALF, LIGHT LID
3	2	D4019-1	RIB
4	2	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET

# SECTION B-B C6-3



DETAIL D C7-3

D4019-101 BASKET LID WELDMENT ASSY

DETAIL C B3-3

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.32 lbs
- 8) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	ALS	D4019	SHEET 3 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

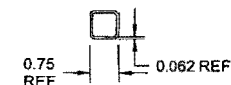
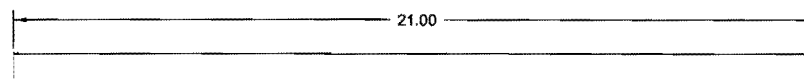
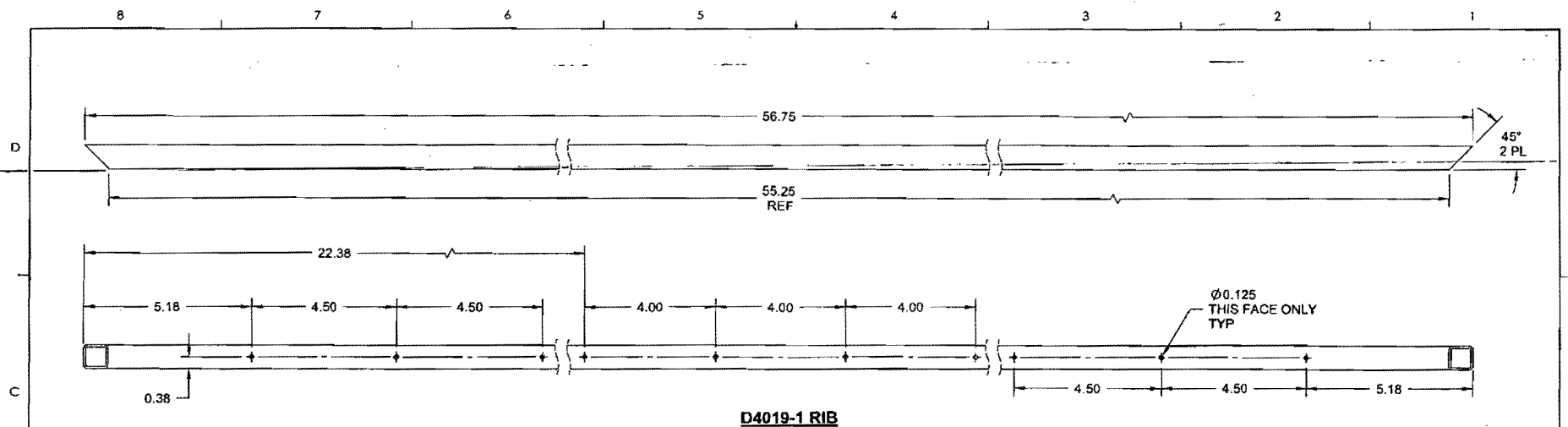
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 0.77 lbs

DESIGN	415	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. F
MFG. APPR.	DA	D4019	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID SHORT BASKET	
DATE	10.08.05	NTS	
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RELEASED  
10.08.12 op

W/O:		WORK ORDER CHANGES					
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